

Work Order ID 72867

Wednesday, August 17, 2011 9:06:06 AM



Page 1

Item ID: DSK081

Accept



Setup Start



Revision ID:

Stop



Item Name: D2940-1 TURNING DETAIL

Start Date: 8/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-08-17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSK081	Rev A

100	MORI SEIKI CNC LATHE LARGE	0.00							
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA079								

ent 11/09/20/
SL 11/9/20

10

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

ent 11/09/20/
SL 11/9/20

10

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

SL 11-09-21

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72867

Wednesday, August 17, 2011 9:06:06 AM



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Item ID: DSK081

Accept



Setup Start



Revision ID:

Stop



Item Name: D2940-1 TURNING DETAIL

Start Date: 8/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: MAT 050

SL 11-09-21

(10)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/22 JF
MF
11-09-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 9:06:12 AM

Page 1

Work Order ID: 72867



Parent Item: DSK081



Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 8/17/2011

Required Date: 8/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007

Manufactured

No

Each

2.0000

10



21 11/9/20

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT046

2

71182

2

72809

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 17, 2011 9:06:22 AM

Work Order ID: 72867



Parent Item: DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 8/17/2011

Required Date: 8/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007

Manufactured

No

Each

2.0000

10



Round Billet, 17-4



Location

Loc Qty

Loc Code

MAT046

2

71182

2

B 72809

ml
11/09/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	22867
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.962	4.957	4.952	4.958	4.958
C	0.718	0.738		.724	.724	.725	.724	.724
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.575	3.575	3.575	3.575	3.575
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132	1.19 →	2.178	2.178	.11	.11	.120
I	2.170	2.190		2.178	2.178	2.178	2.179	2.179
J	4.451	4.471		4.462	4.462	4.462	4.462	4.462
K	0.413	0.433		.433	.430	.430	.430	.430
L	0.913	0.933		.918	.918	.918	.918	.918
M								
N								
O								
P								

Measured by: SA / onl Date: 11/18/20

Audited by: JL Date: 11-09-21

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 12967
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
Lathe Section								
A	3.211	3.216		2.216	2.216	3.213	3.214	3.214
B	4.946	4.966		4.957	4.957	4.956	4.957	4.957
C	0.718	0.738		.724	.724	.725	.725	.725
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.575	3.575	3.576	3.576	3.576
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.120	.119	.121	.121	.120
I	2.170	2.190		2.179	2.178	2.178	2.178	2.178
J	4.451	4.471		4.462	4.462	4.462	4.462	4.462
K	0.413	0.433		.430	.430	.420	.420	.422
L	0.913	0.933		.920	.920	.920	.924	.925
M								
N								
O								
P								

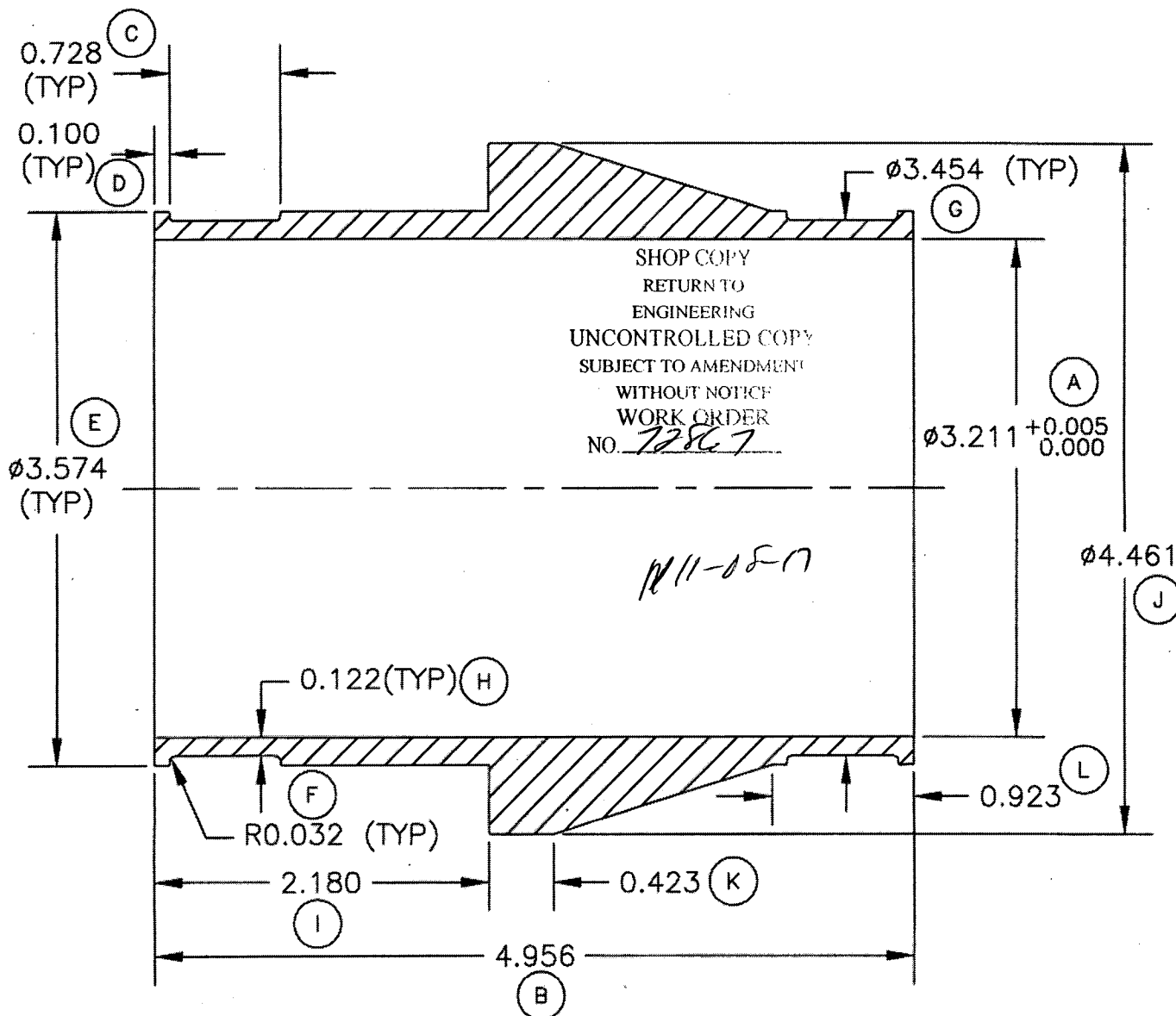
Measured by: SA/amy	Date: 10/5/20
Audited by: JL	Date: 11-09-21
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940--1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03-07-01 *[Signature]*



D2940-1 TURNING DETAIL

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